

# Work Order ID 52256

September 21, 2009 2:31:58 PM



Page 1

Item ID: D3639-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 9/21/09 Start Qty: 12.00



Cust Item ID:

Required Date: 9/24/09 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

*Handwritten signature*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3639

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3639 Dwg Rev: A Prog Rev: A 2-  
Deburr if necessary

B 9-9-22

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-9-22

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

27 S 09/02/22

(16)

/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52256

September 21, 2009 2:31:58 PM

Page 2

Item ID: D3639-3

Accept

Revision ID: A

Item Name: Doubler

Start Date: 9/21/09 Start Qty: 12.00

Required Date: 9/24/09 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3639

0.00

0.00

88 09/10/06

16 0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

278 09/10/06

86 4

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

274 09/10/02

116 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52256

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Page 3

Item ID: D3639-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 9/21/09

Start Qty: 12.00



Cust Item ID:

Required Date: 9/24/09

Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

OK 09-10-7

(K)

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 243

0.00

9/10/8 (100%)



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

09/10/08 MF 09-10-08



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 21, 2009 2:31:57 PM

Page 1

Work Order ID: 52256

Parent Item: D3639-3RevA

Parent Item Name: Doubler

Comments:

Start Date: 9/21/09

Required Date: 9/24/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	131.5566	5.4025	7.2033		



2024-T3 .050 sheet



189922

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

131.5565842

111381

36.3165842

112291

95.24

112291

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 52256
<b>Description:</b> Doubler		<b>Part Number:</b> D3639-3
<b>Inspection Dwg:</b> D3639	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.628	*			
Ø0.191	+0.005/-0.001	.192	*			
Ø0.098	+0.004/-0.001	.101	*			
0.45	+/-0.030	.445	*			
1.350	+/-0.010	1.343	*			
2.25	+/-0.030	2.249	*			
3.15	+/-0.030	3.149	*			
4.05	+/-0.030	4.050	*			
4.95	+/-0.030	4.952	*			
5.85	+/-0.030	5.853	*			
6.75	+/-0.030	6.749	*			
7.65	+/-0.030	7.656	*			
8.55	+/-0.030	8.552	*			
9.350	+/-0.010	9.354	*			
9.45	+/-0.030	9.454	*			
10.350	+/-0.010	10.351	*			
11.25	+/-0.030	11.254	*			
12.15	+/-0.030	12.15	*			
12.85	+/-0.030	BEND				
13.86	+/-0.030	13.86	*			
13.96	+/-0.030	13.96	*			
0.805	+/-0.010	.806	*			
1.00	+/-0.030	1.002	*			
2.100	+/-0.010	2.100	*			
3.30	+/-0.030	3.308	*			
2.000	+/-0.010	2.004	*			
2.590	+/-0.010	2.590	*			

<b>Measured by:</b> HB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-9-22	<b>Date:</b> 07/09/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	DS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

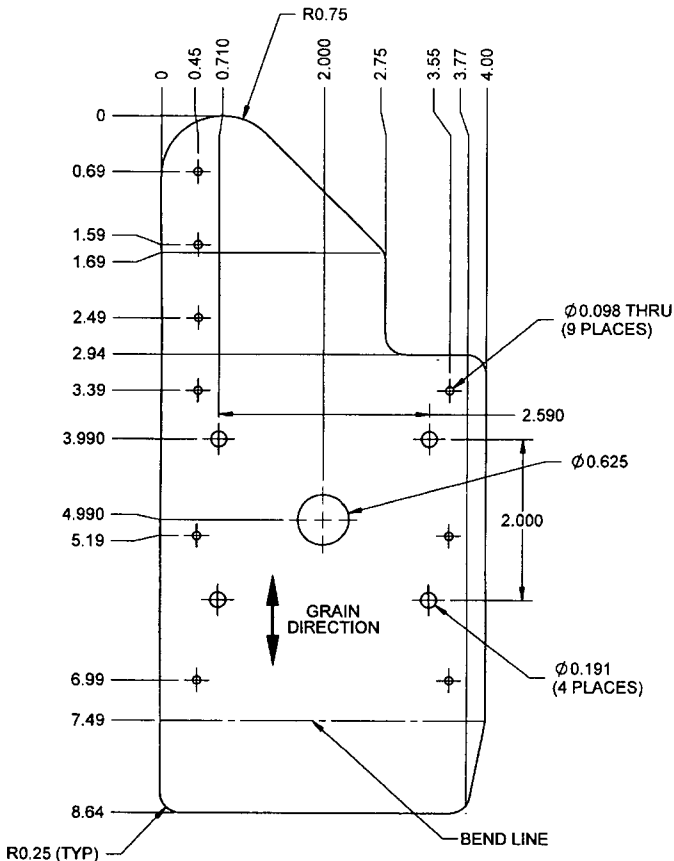
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

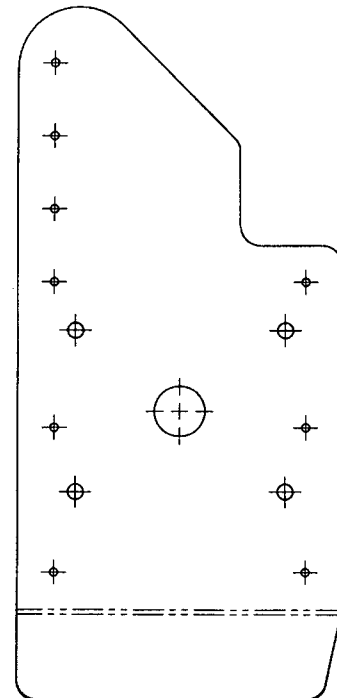
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

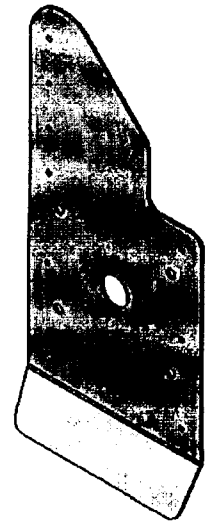
w/o 52256



**D3639-1F FLAT PATTERN**  
**(D3639-2F OPPOSITE)**



**D3639-1 DOUBLER**  
**(WAS GENEVA P/N G10604-3)**  
**D3639-2 OPPOSITE**  
**(WAS GENEVA P/N G10604-6)**

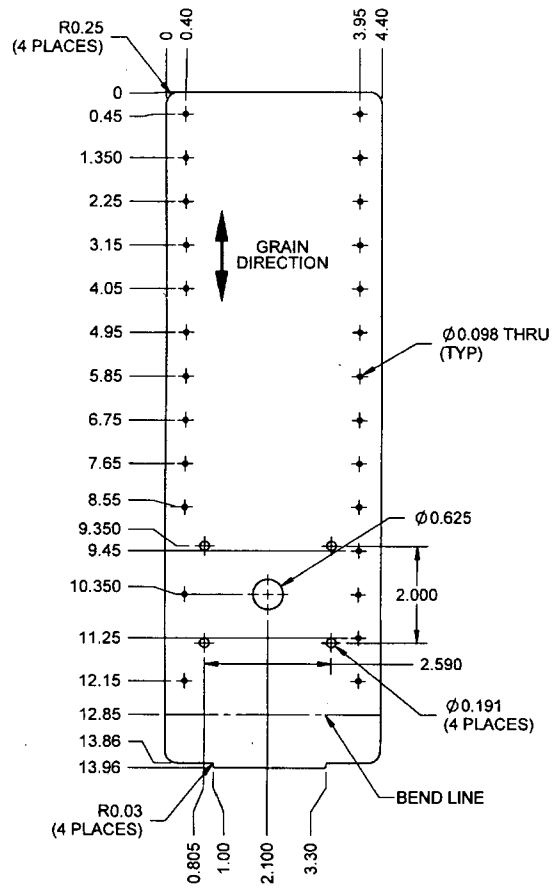


**RELEASED**  
07-07-07

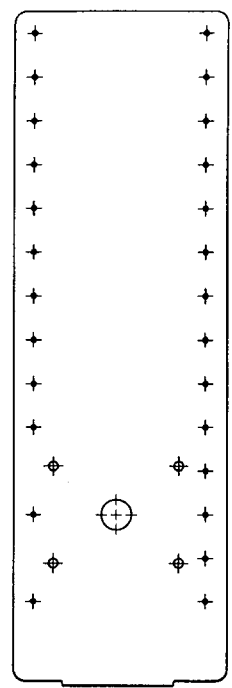
- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.14 lbs

A	NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC.		
DRAWN	LE	PORT HADLOCK, WA		
CHECKED	LE	DRAWING NO.	REV. A	
MFG. APPR.	LE	D3639	SHEET 1 OF 2	
APPROVED	LE	TITLE	SCALE	
DE APPR.	LE	DOUBLER	2:3	
DATE	07.07.27			
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WFO 52256



**D3639-3F FLAT PATTERN**  
**(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER**  
**(WAS GENEVA P/N G10604-4)**  
**D3639-4 OPPOSITE**  
**(WAS GENEVA P/N G10604-5)**

**RELEASED**  
07.09.07

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	B	D3639	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	#	DOUBLER	2.5
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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